

Work Order ID 74524



Page 1

Monday, October 03, 2011 4:03:16 PM

Item ID: D3294-5

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/04

Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr

100



Waterjet

FLOW CNC Waterjet

7024 .080

0.00

B11-10-26

Memo

0.00

1-Cut as per Dwg D3294

Dwg Rev: C

Prog Rev: C

****grain direction as per dwg D3294 ****

2-Deburr if necessary

B11-10 - 28

(SC)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

B11-10-26

Memo

0.00



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

S u1u(28)

counts

(t20)

130



Brake NC

Memo

0.00

SB 11/11/10

(20)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S u1u10

counts

(t20)

Memo

1- Deburr if necessary

2- Bend as per Dwg D3294

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Chemical Conversion Coat per QSI005 4.1

0.00

20x S M - 11/11/10

HandFinish

Memo

0.00

Hand Finishing

160



QC3- Inspect Part Finish

0.00

20 BL 11-11-10

QC

Memo

0.00

Quality Control

170



Identify as per dwg & Stock Location: STGA

0.00

SP 11-11-10

Packaging

Memo

0.00

Packaging

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Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

180



QC21- Final Inspection - Work Order Release

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

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Picklist Print

Page 1

Monday, October 03, 2011 4:03:22 PM

Work Order ID: 74524



Parent Item: D3294-5



Parent Item Name: Doubler

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	245.3000	0.065	0.821053	1.5		

2024-T3 .080 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	245.3	
105411	6	
109424	4	
110347	0.5	
112331	3	
113796	7	
114025	15.7	
116604	5.8	
117392	40.1	
118180	67.2	118180
119117	96	

(2)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74524
Description: Doubler	Part Number:	D3294-5
Inspection Dwg: D3294 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B
Date:	11-10-26

Audited by: S

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

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D							D																																												
C							C																																												
B							B																																												
A							A																																												
<p>D3294-1 BRACKET ASSEMBLY</p>																																																			
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">ITEM NO.</th><th style="text-align: center;">QTY. -1</th><th style="text-align: center;">PART NUMBER</th><th style="text-align: center;">DESCRIPTION</th></tr> </thead> <tbody> <tr> <td style="text-align: center;">1</td><td style="text-align: center;">X</td><td style="text-align: center;">D3294-1</td><td style="text-align: center;">BRACKET ASSEMBLY</td></tr> <tr> <td style="text-align: center;">2</td><td style="text-align: center;">1</td><td style="text-align: center;">D3294-3</td><td style="text-align: center;">BRACKET</td></tr> <tr> <td style="text-align: center;">3</td><td style="text-align: center;">1</td><td style="text-align: center;">D3294-5</td><td style="text-align: center;">DOUBLER</td></tr> <tr> <td style="text-align: center;">4</td><td style="text-align: center;">15</td><td style="text-align: center;">MS20470AD4-5</td><td style="text-align: center;">RIVET</td></tr> </tbody> </table>								ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION	1	X	D3294-1	BRACKET ASSEMBLY	2	1	D3294-3	BRACKET	3	1	D3294-5	DOUBLER	4	15	MS20470AD4-5	RIVET																								
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<p>SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. <u>74524 M.L.J.</u></p> <p><i>11/10/04</i></p>																																																			
<p>RELEASED <i>09/10/04</i></p>																																																			
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">C</td><td style="width: 80%;">REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET S+6.</td><td style="width: 10%; text-align: right;"><i>AB</i></td><td style="width: 10%;">09.03.24</td></tr> <tr> <td>B</td><td>CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2.</td><td>HS</td><td>08.09.22</td></tr> <tr> <td>A</td><td>NEW ISSUE</td><td>CP</td><td>04.06.28</td></tr> <tr> <td>REV.</td><td>DESCRIPTION</td><td>BY</td><td>DATE</td></tr> <tr> <td>DESIGN</td><td><i>AB</i></td><td colspan="2" style="text-align: center;">DART AEROSPACE LTD</td></tr> <tr> <td>DRAWN</td><td><i>AB</i></td><td colspan="2" style="text-align: center;">HAWKESBURY, ONTARIO, CANADA</td></tr> <tr> <td>CHECKED</td><td><i>AB</i></td><td>REV. C</td><td></td></tr> <tr> <td>MFG. APPR.</td><td><i>AB</i></td><td colspan="2">DRAWING NO. D3294 SHEET 1 OF 6</td></tr> <tr> <td>APPROVED</td><td><i>AB</i></td><td>TITLE</td><td>SCALE</td></tr> <tr> <td>DE APPR.</td><td><i>AB</i></td><td colspan="2">BRACKET NTS</td></tr> <tr> <td>DATE</td><td colspan="3">09.03.24</td></tr> </table>								C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET S+6.	<i>AB</i>	09.03.24	B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2.	HS	08.09.22	A	NEW ISSUE	CP	04.06.28	REV.	DESCRIPTION	BY	DATE	DESIGN	<i>AB</i>	DART AEROSPACE LTD		DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA		CHECKED	<i>AB</i>	REV. C		MFG. APPR.	<i>AB</i>	DRAWING NO. D3294 SHEET 1 OF 6		APPROVED	<i>AB</i>	TITLE	SCALE	DE APPR.	<i>AB</i>	BRACKET NTS		DATE	09.03.24		
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DE APPR.	<i>AB</i>	BRACKET NTS																																																	
DATE	09.03.24																																																		

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

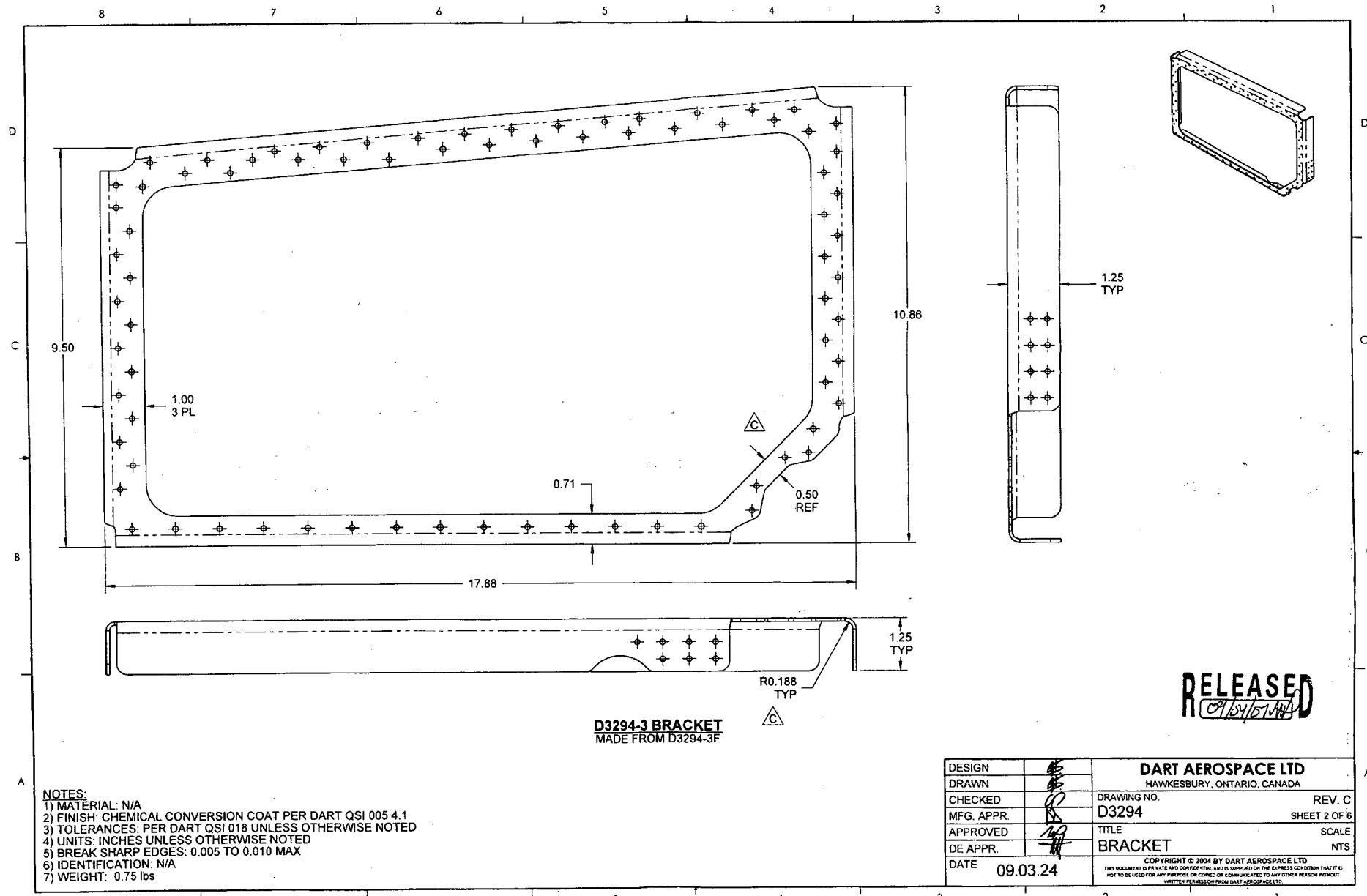
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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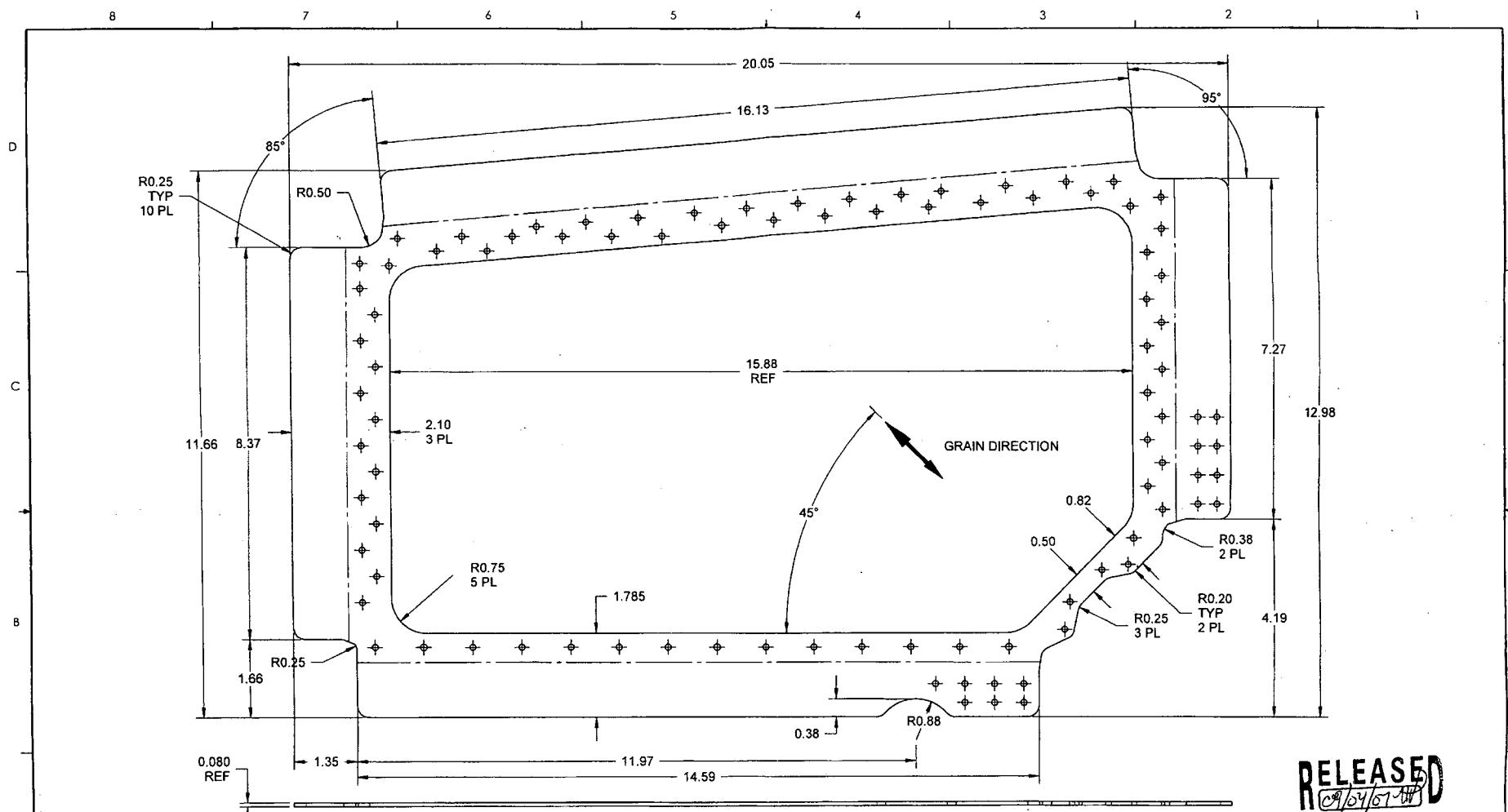
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74524



D3294-3F BRACKET FLAT PATTERN

RELEASED
C9/04/07

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. C
MFG. APPR.		D3294
APPROVED		SHEET 3 OF 6
DE APPR.		TITLE
DATE	09.03.24	SCALE
		NTS

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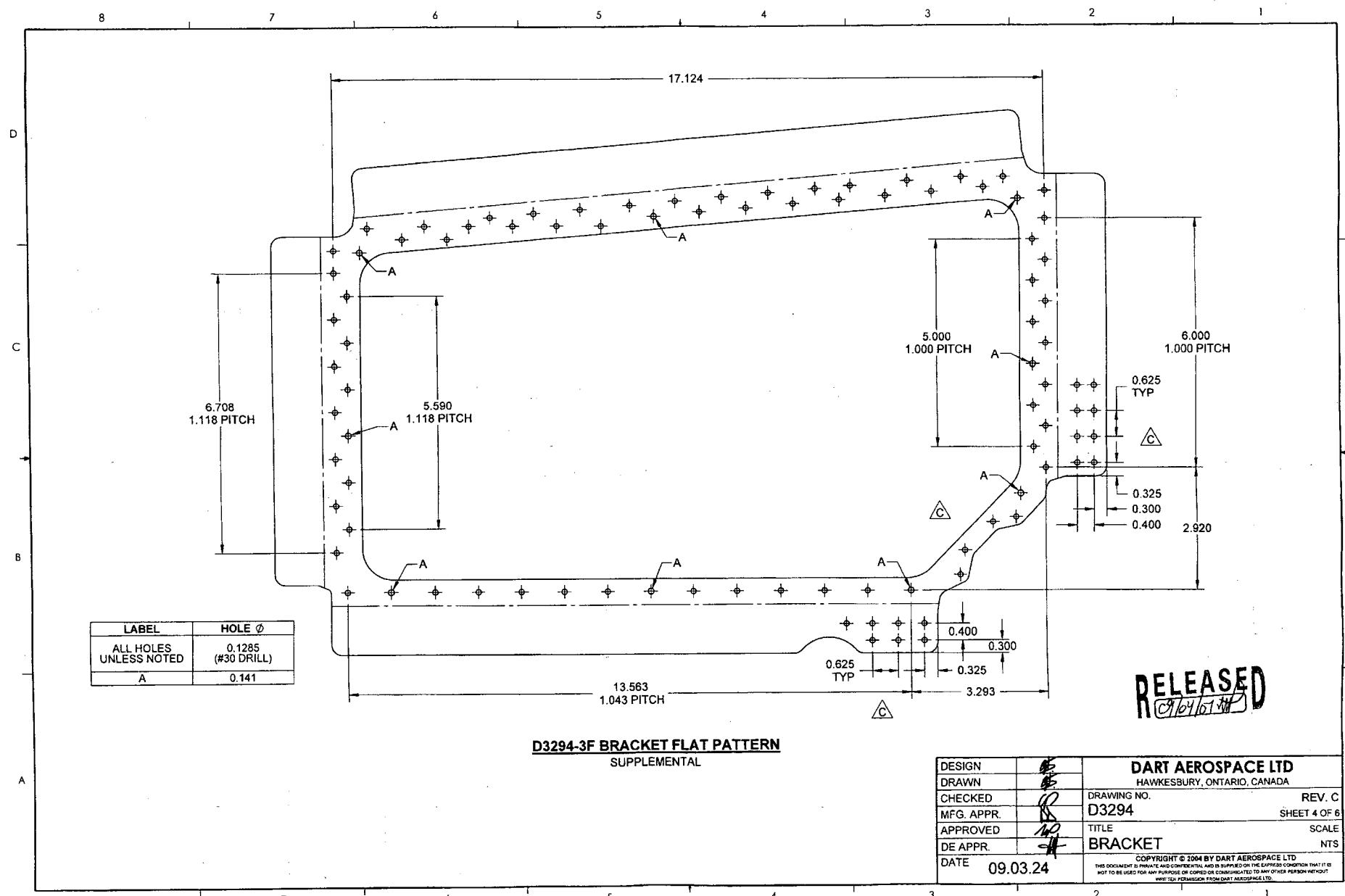
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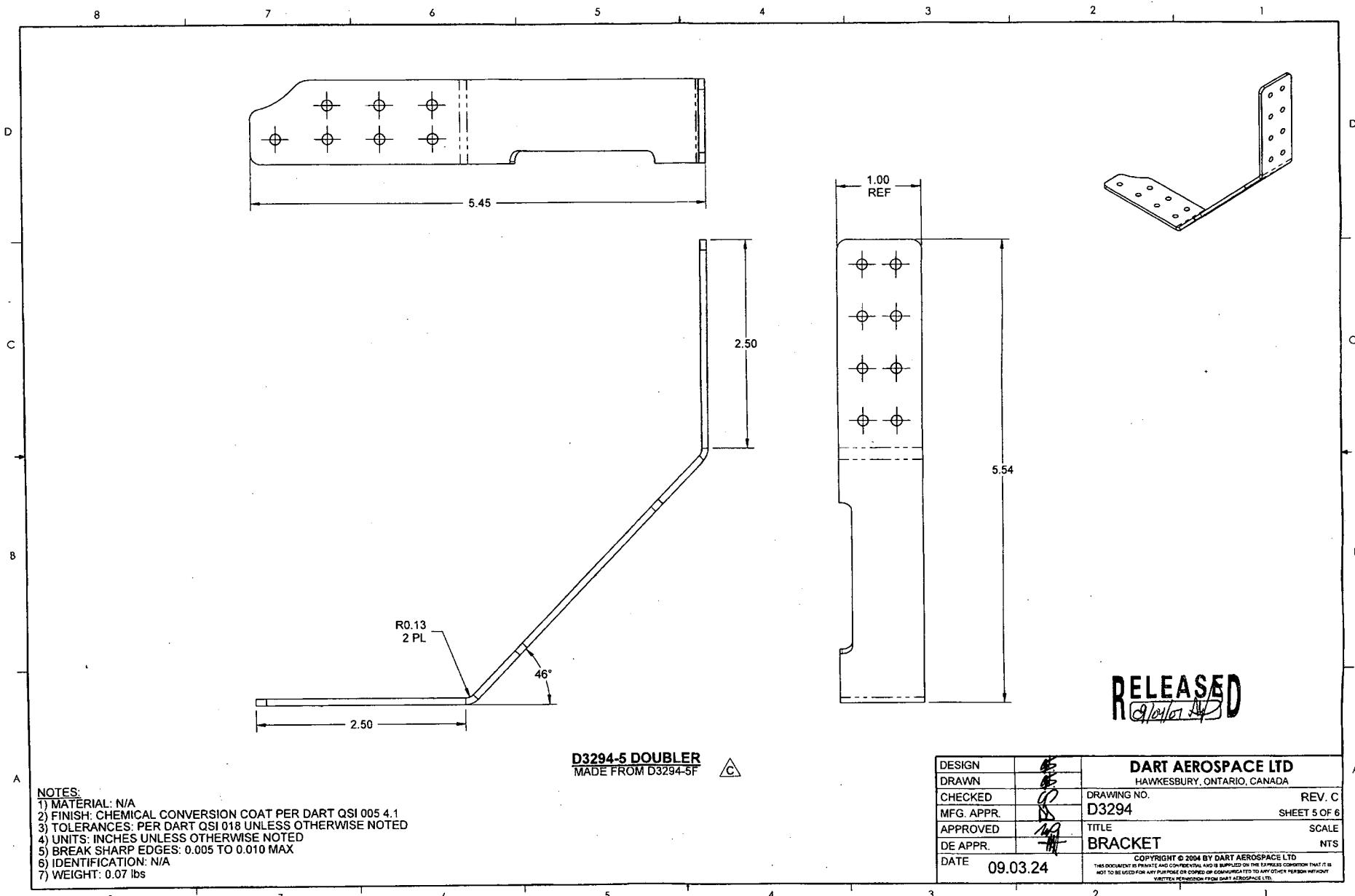
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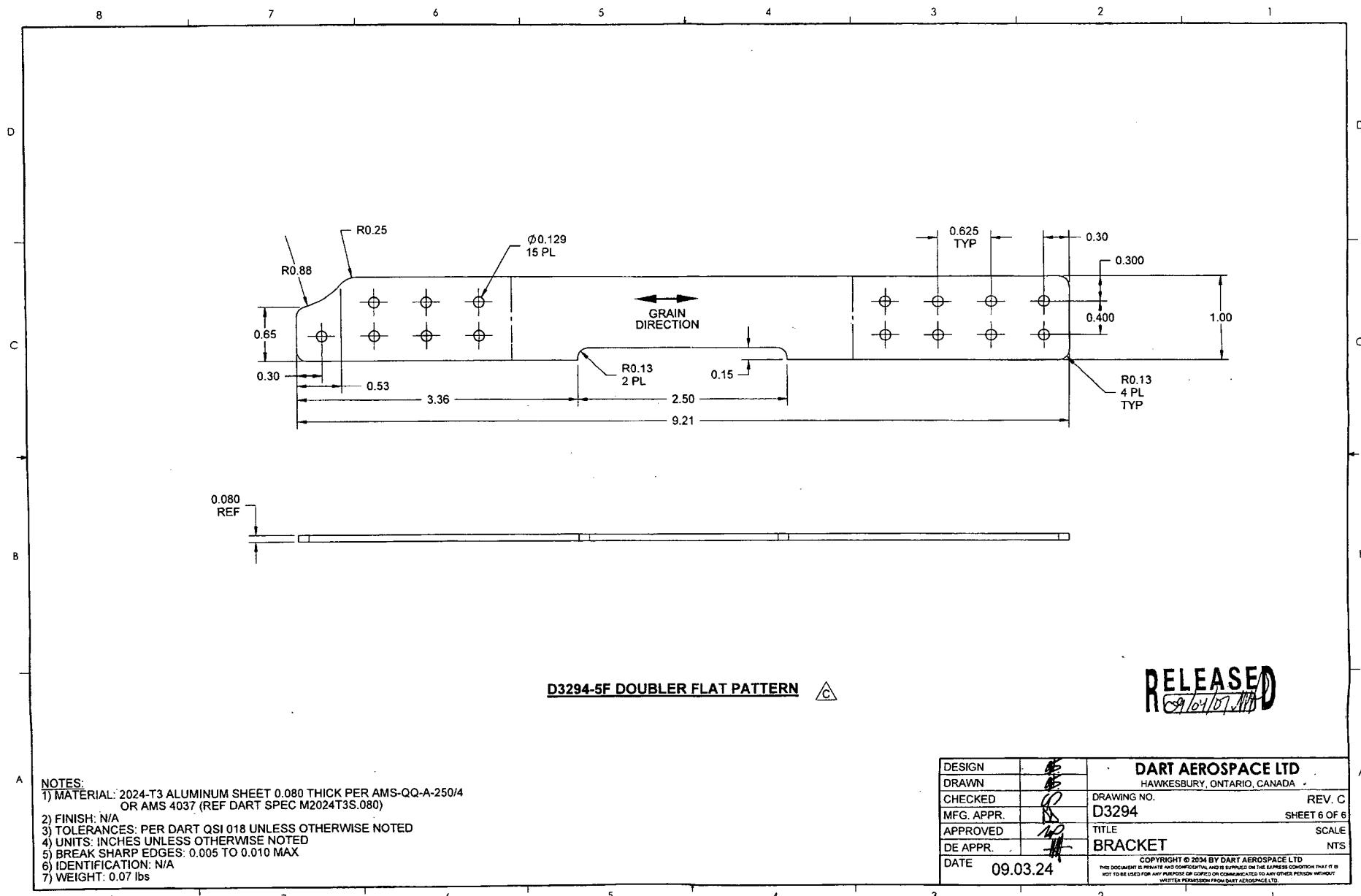
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries